Tem ID:	ge 1
Start Date: 5/26/2010 Start Qty: 2.00 Required Date: 6/4/2010 Req'd Qty: 2.00 Cust Item ID: Customer: Reference: Approvals: Process Plan: QC: Date: SPC (Y/N): Date: SPC (Y/N): Date: Sequence ID/ Work Center ID Description Run Start William Start Wil	
QC:	i s i
Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr Revision Nbr D4038 B	
Draw Nbr Revision Nbr D4038 B	
4	
0.00	
Bandsaw Memo Cut Blank 7.125" long Cut blank 7.125" long Cut blank 7.125" long	
HAAS 1 HAAS CNC vertical machine #1 Memo Mill as per Dwg & Folio FA880 Dwg Rev: Folio Rev: Folio Rev: AA DoloGoo Dologoo Folio Rev: AA Dologoo Memo Dologoo Dologoo Dologoo Dologoo Dologoo Dologoo Dologoo Dologoo Folio Rev: AA Dologoo Folio Rev: AA Dologoo Dolo	

W/0:59	3/20	Liu	WORK ORDER CHANGES					, , ,
			WORK ORDER CHANGES			· · · · · · ·	Approval	· ;
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector
6/06/03	100	Change Memo f	Sr: Cut blank 7,625" long	DIF	10/06/03		10.06.04	2
			ferm change //		D.00.08			10.06.04
Part No:		PAR #:esolution:Scr	0	\sim	No DQA		Date: <u>/</u>	10/06/03 10/06/08
NCR: 54	1/38	W	ORK ORDER NON-CONFORMANC	E (NC	R)	<u> </u>		
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description Chief Eng Chief Eng	Sign	I Section		Approval Chief Eng	Approval QC Inspector
<i>10 06</i> 03	110	first part Scrap Wrong info in folio Origine at wrong place			P . 5	63	hogun	1006 al
		R.C. Pregvan aver.					107	
NOTE: D	9 :	al all entries						

Work Ord Wednesday, Ma													Page 2
Item ID: Revision ID:	D4038-4				Accept					Setup	Start		
Item Name:	Angle, Aft, R	Н	•								Stop		
Start Date: Required Date: Reference:	5/26/2010 6/4/2010	Start Qty: 2.00 Req'd Qty: 2.00				Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:		Tooling:	Ds	ate:	_		Run	Start		
	QC:		Date:		SPC (Y/N):		ate:		,		Stop		
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
QC Quality Control		QC2- Inspect parts off m Memo	nachine FAI/FAI	ΙΒ	0.00	-10/0s/3			2				
130		QC8- Inspect parts - seco	ond check		0.00 my	l 10/06/07						-	
QC Quality Control		Memo			0.00				_2				

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00 7m l w/06/07 (2x)

W/O:			V	VORK ORDER CHANC	GES			
DATE	STEP	PRO	OCEDURE CI	- Letter 1997	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				A Company of the Comp				
Part No	•	PAR #:	Fault Ca	itegory:	NCR: Yes	No DQA:	Date: _	
	Res	olution:	Disposit	tion:	QA: N/C Cld	osed:	Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC	Initial		tion B	Verification	Approval	Approval
· .		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							·	-

Work Order ID 59138	W	ork	Or	der	ID	59 1	138
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Wednesday, May 26, 2010 1:55:32 PM



Page 3

Item ID:

D4038-4

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Angle, Aft, RH

Required Date: 6/4/2010

5/26/2010

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Tool#

Plan

Code

Stop

Reject

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

150

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Run Hours

0.00

Reject

Qty

160

Packaging

Packaging

Identify as per dwg & Stock Location: B59134 0.00 SB 18/06/07

Accept

Qty

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

0.00

10/06/08 H)
p(10-6-08

	-								, n
W/O:			W	ORK ORDER CHANG	iES				,,,
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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-			4						
			٠.						
Part No		PAR #:	Fault Cat	egory:	_ NCR: Ye	es No DO	QA:	Date:]
	R	esolution:	Dispositi	on:	_ QA: N/C	Closed: _		Date: _	
NCR:		,	WORK ORI	DER NON-CONFORM	ANCE (N	CR)	·····		
DATE	STEP	Description of NC	Initial		ion B		ication	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Da	n & Sec	ction C	Chief Eng	QC Inspector
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· · · · · · · · · · · · · · · · · · ·			·						,
			•.						

Picklist Print

Wednesday, May 26, 2010 1:55:37 PM

Work Order ID: 59138

Comments:

Parent Item: D4038-4

D4030-4

Parent Item Name: Ang

Angle, Aft, RH

Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Date: 5/26/2010

Required Date: 6/4/2010

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250	•	Purchased	No			100	f	20.1684	0.7	1.473684			<u>. </u>
							÷			1.175001			

6061T6 ANGLE 4.00 x 4.00 x .250

Location	Loc Qty	Loc Code
MAT	20	
114407	20	•
MAT06	0.1684	
113391	0.1684	

10/06/03

M 114507

1.1875(F) 0,5938(F)

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng/ Prod Mgr OC Inst Part No:PAR #:Fault Category: NCR: Yes No DQA:Date: Resolution:Disposition: QA: N/C Closed:Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC	W/O:			WO	RK ORDER CHANG	ES				
NCR: WORK ORDER NON-CONFORMANCE (NCR)	DATE	STEP	PR				Date	Qty	Chief Eng /	Approval QC Inspector
NCR: WORK ORDER NON-CONFORMANCE (NCR)										
NCR: WORK ORDER NON-CONFORMANCE (NCR)										
NCR: WORK ORDER NON-CONFORMANCE (NCR)								30, 31, 31, 31, 31, 31, 31, 31, 31, 31, 31		
NCR: WORK ORDER NON-CONFORMANCE (NCR)	Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQA	:	Date:	
DATE STEP Description of NC Section A Initial Chief Eng										
STEP Section A Initial Chief Eng Action Description Chief Eng Section C Section C Chief Eng Action Description Chief Eng Chief	NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR)			
Chief Eng Chief Eng Date	DATE	STEP	Description of NC Section A		Action Description	Sign &	Section			Approval QC Inspector
				Chief Eng	Chief Eng	Date	Georgi		Office Eng	QO mapector
								-		

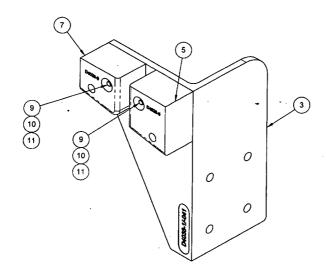
DART AEROSPACE LTD	Work Order:	59/38
Description: Angle, AFT, RH	Part Number:	4038-4
Inspection Dwg: 4048-4 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	cle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
4,00	±0,030	3,991	1/2			2PL	REF
1,25	±0,030	1,238				R	EF
1,25	±0,030	1,25.	V,			R	ef
1,25 1,25 0,250	±0,010	0,240				R	EF
R1,00	±0,030	1,00					
0,50	±0,030	0,499	1			RE	F.
1,750	±0,010	1,748					
1,270	±0,010	1,268	7.				
0,714	±0,010	0,712					
2,125	±0,010	2,122					
\$0.316	to 1006/-0,001		/			6P	L
0,581	±0,010	0,571					
1,500	±0,010	1,500					
0,70	ta.020						
\$0,189	to,005-0,001	0,70				2PI	-
2,00	±0,030	2,00					
7,50	±0,030	7,50	/				
Measured by:	Ta	Audited by:	Omp		Prototype Ap	proval:	N/A
Date:	10/06/03	Date:	10/06/0	 -		Date:	N/A
Rev Date	Change				Rev	ised by	Approved

KJ/JLM

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		х	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		. 1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER



D4038-041 ANGLE ASSEMBLY, FWD, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -041 - 1.76 lbs
-042 - 1.74 lbs

DRAWING NO. CHECKED D4038 MFG. APPR. APPROVED TITLE **BRACKET** DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
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D4038-042 ANGLE ASSEMBLY, FWD, RH

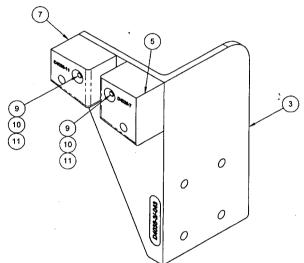
DELEASE N 2010 -04-14

REVISED DIMENSIONS ALL SHEETS, ADD ϕ 0,316 HOLES IN -1/-2/-3/-4 PARTS, ADD RADIUS TO -1/-2/-3/-4 PARTS 10.01.05 Α NEW ISSUE H\$ 09.12.14 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA REV. B SHEET 1 OF 14 SCALE

3

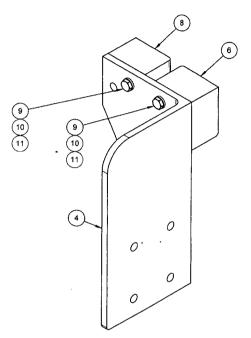
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W/O:			WO	RK ORDER CHANG	GES				· ·
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						· · · · · · · · · · · · · · · · · · ·			
Part No		PAR #:							
	Reso	olution:	Disposition	l:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial		ction B	Verific	cation	Approval	Approval
		Section A		Action Description Chief Eng	Sign Date			Chief Eng	QC Inspector
·									
			1 ' 1		1	1			ŀ

8		,	7	6 5
ITEM NO.	QTY. -043	QTY. -044	Part Number	DESCRIPTION
1	х		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
. 8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER



D4038-043 ANGLE ASSEMBLY, AFT, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -043 - 1.91 lbs
-044 - 1.74 lbs



3

D4038-044 ANGLE ASSEMBLY, AFT, RH

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С

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 2 OF 14 APPROVED TITLE SCALE DE APPR. **BRACKET** NTS DATE

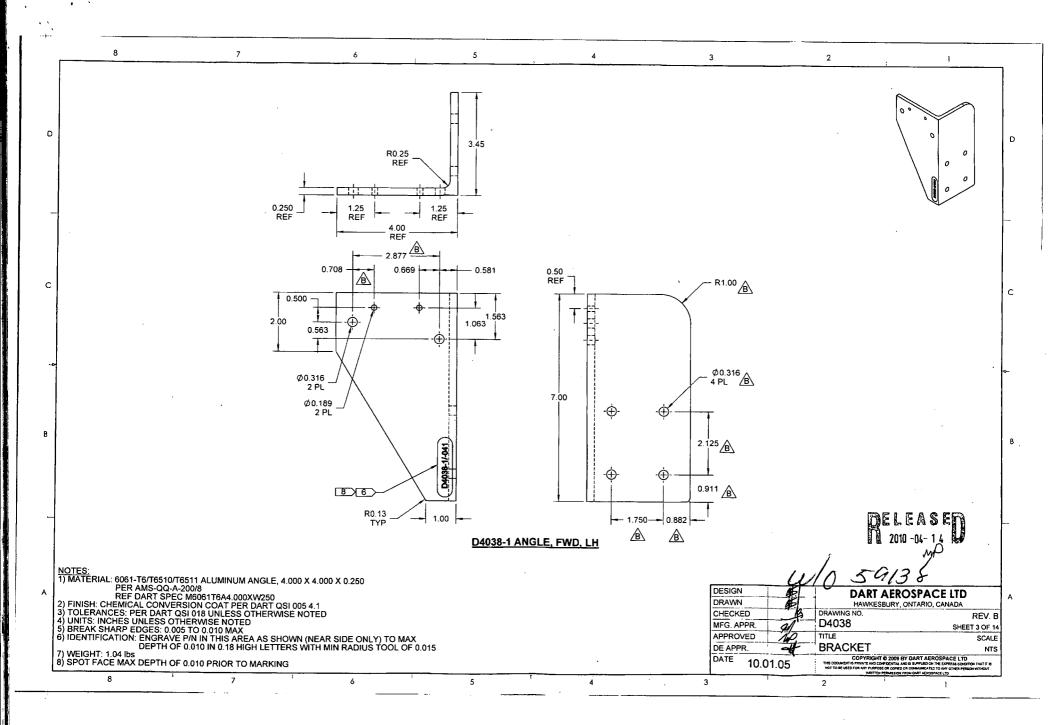
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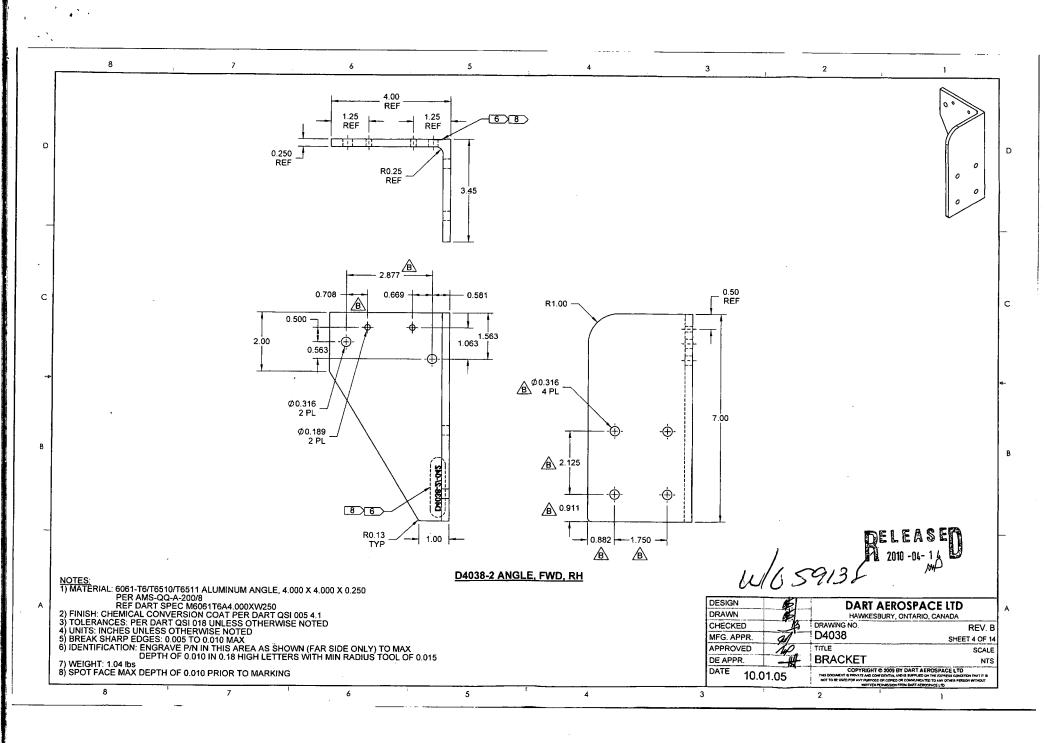
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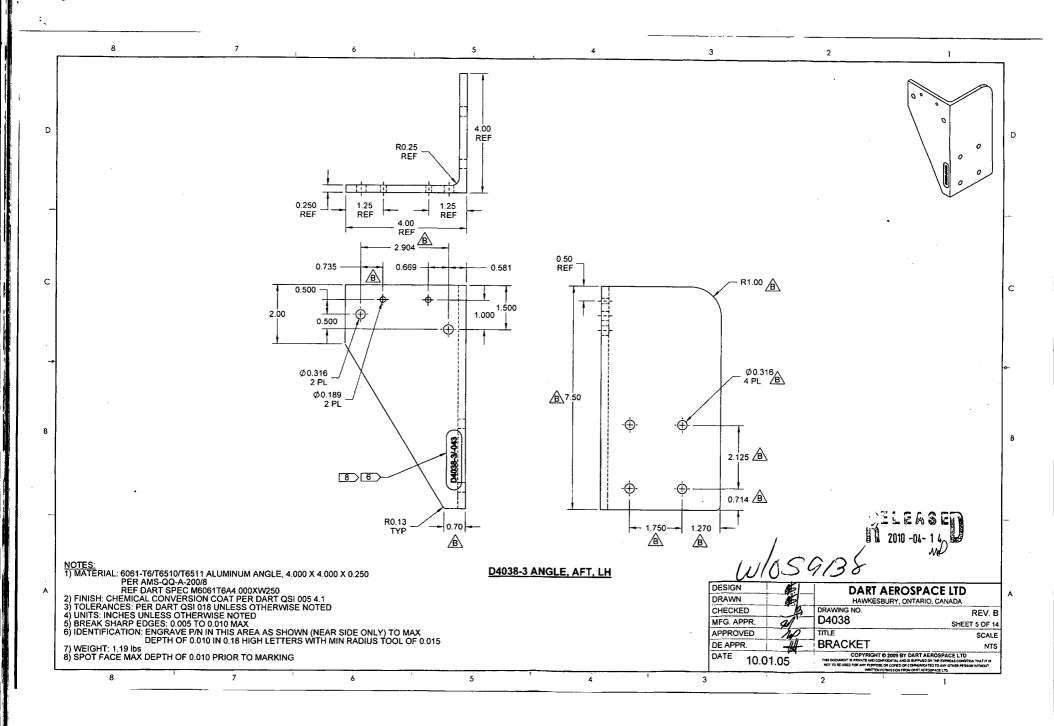
W/O:	**		CHANGES							
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	!	•								
Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes	No DQ	\ <u>.</u>	Date:	
		esolution:								
NCR:		V	WORK ORD	DER NON-CONFOR	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descripti		Section B	Sign &	Verific Section		Approval Chief Eng	Approval
·		occion /	Chief Eng	Chief Eng		Date	Secu		Chief Eng	QC Inspector



W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:	Date: _					
	Res	solution:	Disposition	on:	_ QA: N/C CI	osed:	Date: _					
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCF	R)						
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval				
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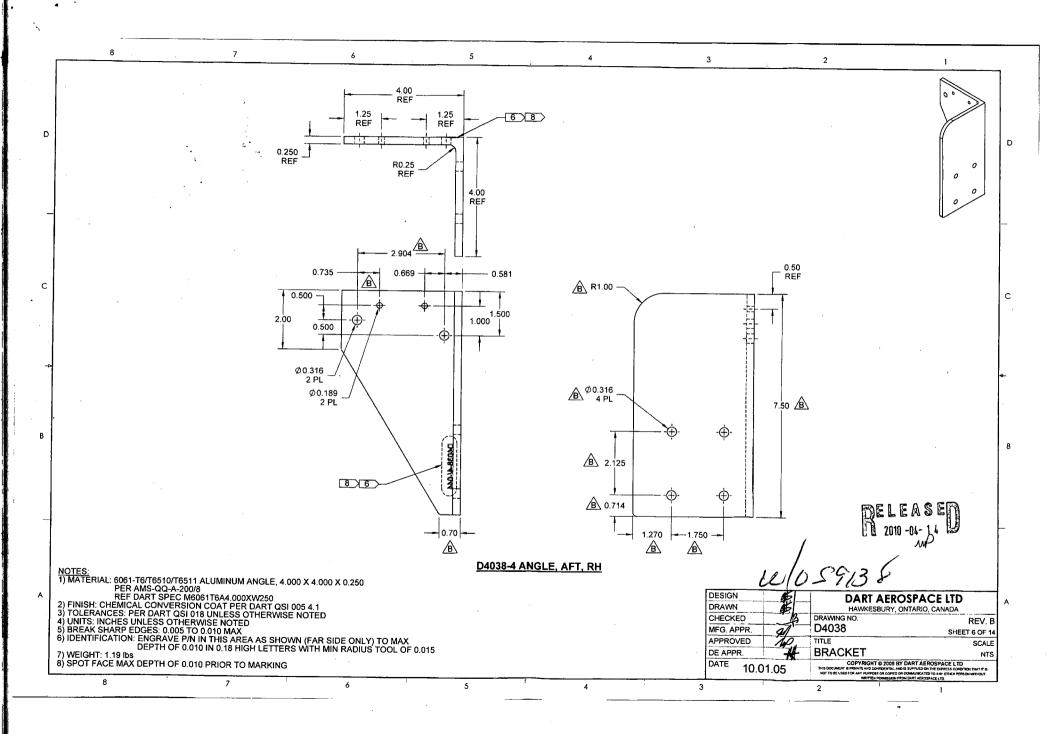


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NCR:			WORK ORE	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	1	·	tion B	Verifica		Approvai	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	С	Chief Eng	QC Inspector
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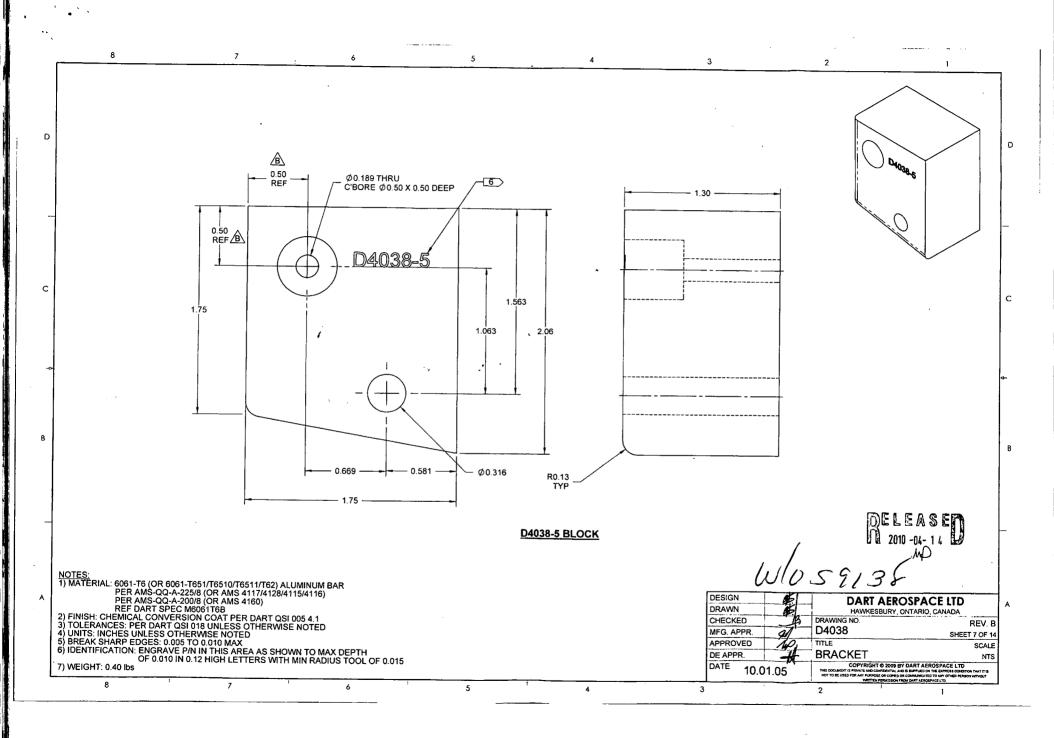


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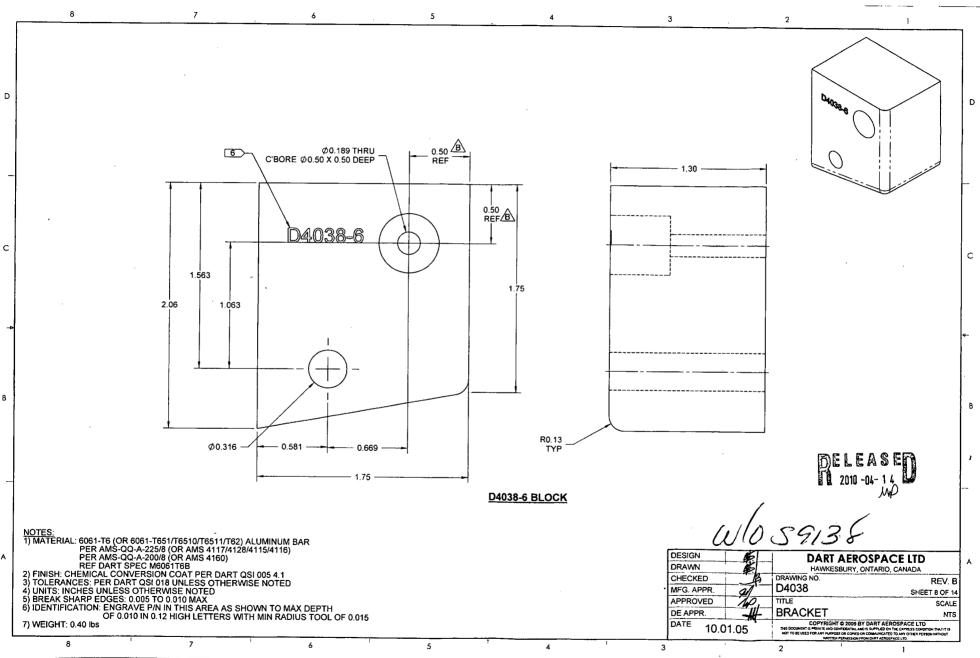
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DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Ca	tegory:	N	CR: Yes	No DQA :		_ Date: _			
	Re	esolution:	Disposit	ion:	G	A: N/C CI	osed:		Date:			
NCR:			WORK OR	DER NON-CO	NFORMANO	E (NCR)					
DATE	STEP	Description of NC Section A	Initial Chief Eng			Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector		
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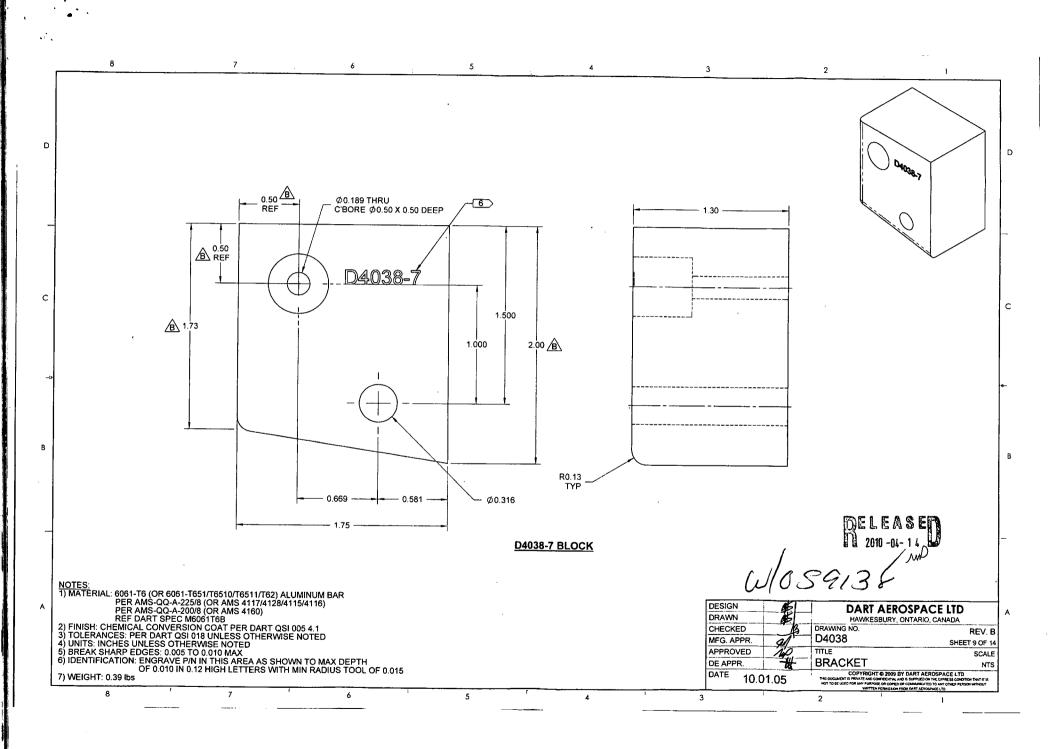
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DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	Res	solution:	Dispositio	n:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Initial		tion B		Verific	ation	Approval	Approval
		Section A		Action Description Chief Eng	on Sign & Date		Section C		Chief Eng	QC Inspector
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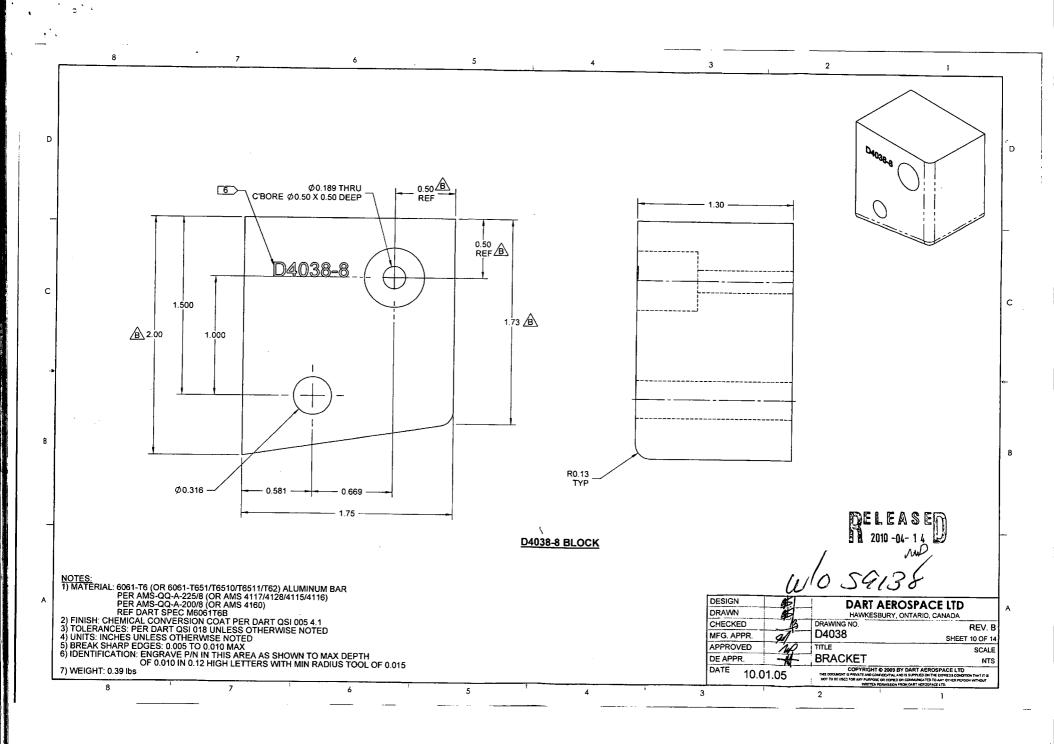
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DATE	STEP	PRO	DCEDURE CHA	NGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						; ;						
Part No	:	PAR #:	Fault Cate	egory:	_ NCR:	Yes N	lo DQA	\:	_ Date: _			
	R	esolution:	Disposition	Disposition: QA: N/C Closed:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE (I	VCR)				· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval		
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section C		Chief Eng	QC Inspector		
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						, , , , , , , , , , , , , , , , , , , 		V-1-10-				
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W/O:			WO	RK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cated	orv:	NCR: Yes	No DO	Δ.	Date:		
			Disposition: Q							
NCR:				R NON-CONFORM						
DATE		Description of NC Corrective Action			ion B	Vorifi	cation	Approval		
DATE	STEP	Section A	Initial Action Desc Chief Eng Chief Eng				ion C	Chief Eng	Approval QC Inspector	

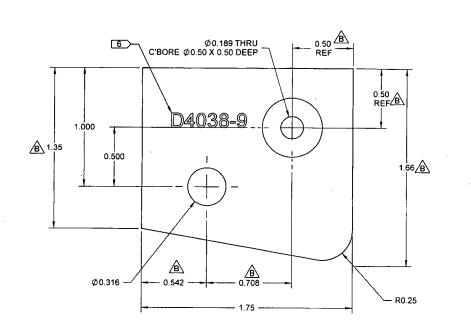


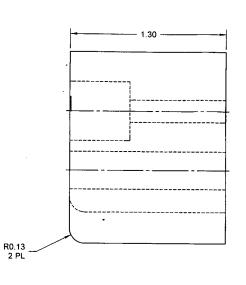
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Part No	•	PAR #:	Fault Cate	jory:	NCR: Y	es N	lo DQ .	A:	_ Date: _		
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC	Initial		tion B		Verific	cation	Approval	Approval	
		STEP Section A		Action Description Chief Eng	tion Sign & Date			on C	Chief Eng	QC Inspector	
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W/O:			W	ORK ORDER CHANG	iES			, , +	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date:	·	
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DATE	STEP	Description of NC			ion B	Verification	Approval	Approval	
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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			-						





D4038-9 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE PIN IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 11 OF 14 APPROVED SCALE **BRACKET** DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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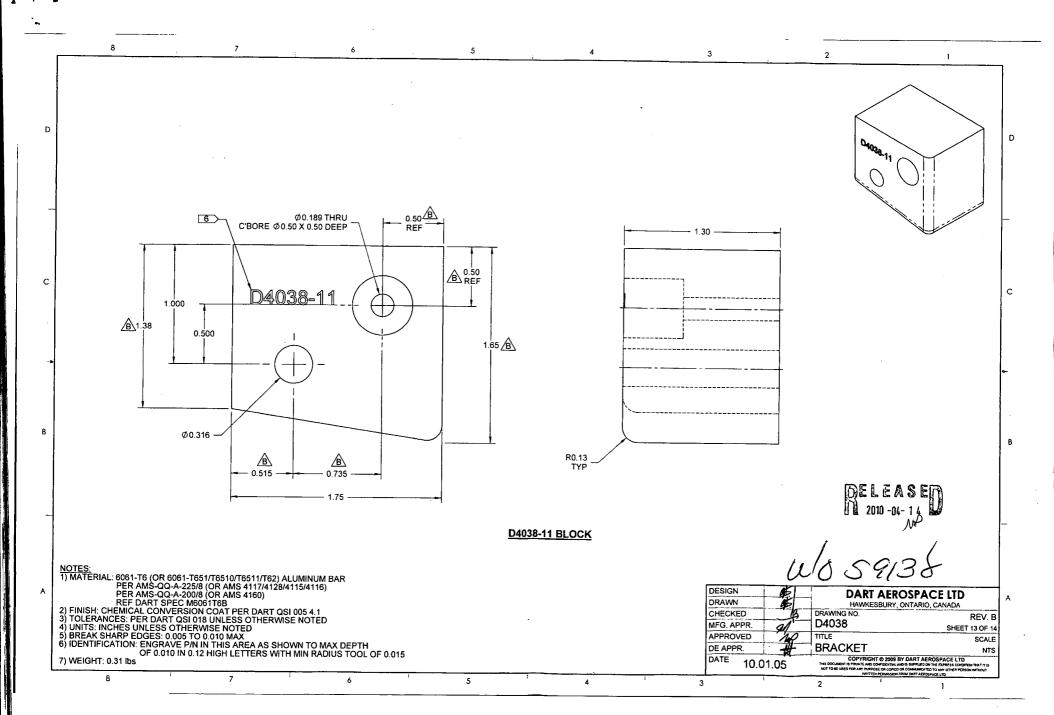
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date: _					
	Res	olution:	Disposition: C			QA: N/C Closed: Date:				
NCR:			WORK ORDI	R NON-CONFORM	MANCE (NO	R)				
DATE	STEP	Description of NC	Initial	ection B	tion B Sign & Verificat			Approval		
		Section A	Chief Eng	Action Description Chief Eng	Dat		on C	Chief Eng	QC Inspector	
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- 0.50 B Ø0.189 THRU C'BORE Ø0.50 X 0.50 DEEP 1.30 Ø 0.50 REF D4038-10 1.000 1.35 🛕 0.500 B 1.66 Ø0.316 R0.13 ◬ ß 2 PL 0.708 0.542 **D4038-10 BLOCK** NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M606116B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4038 MFG. APPR. SHEET 12 OF 14 APPROVED TITLE SCALE **BRACKET** DE APPR. NTS DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD
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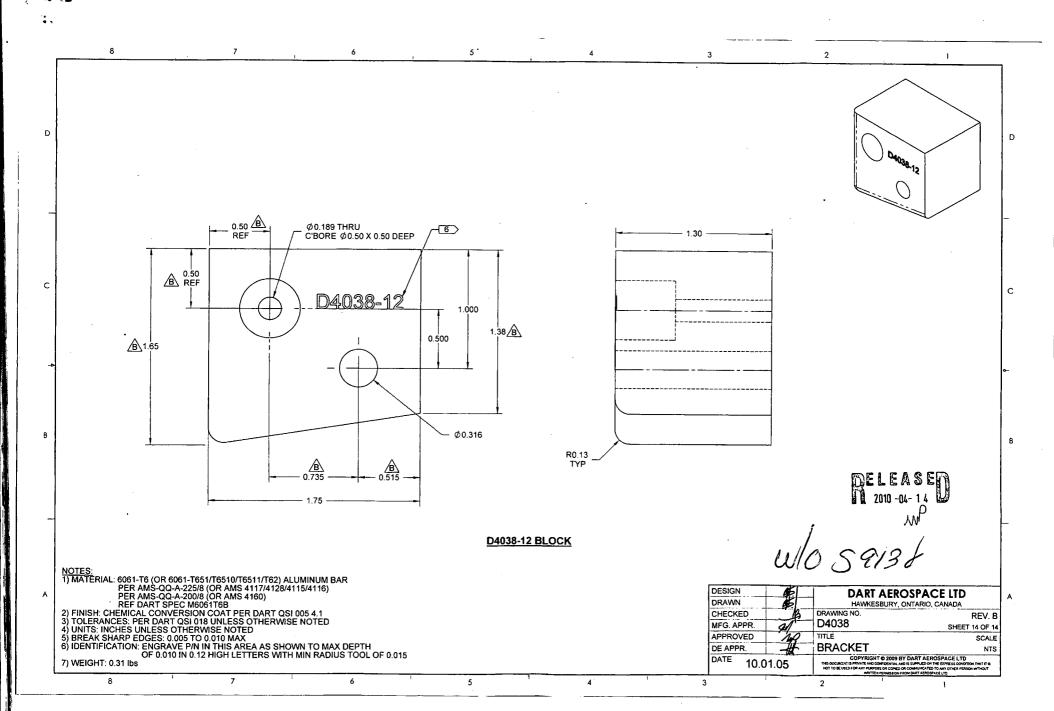
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W/O:		WORK ORDER CHANGES										
DATE STEP		PRO	PROCEDURE CHANGE					Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA :	Date:					
		esolution:										
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DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval QC Inspector				
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng					
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		PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:							
		esolution:					Date:					
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DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval Chief Eng	Approval QC Inspector				
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NCR:		· V	VORK OR	DER NON-CONFOR	MANCE	(NCR)	74.4.7.					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Description Chief Eng	Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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